

Date: Thursday, 10/18/2007 7:59:02 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET & CLAMP ASSEMBLY
Job Number : 35192	
Estimate Number : 12255	
P.O. Number : <i>N/A</i>	Part Number : D3481043
This Issue : 10/18/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3481 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 28577	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/24/2007 Qty: <i>5</i> Um: Each
Checked & Approved By : <i>[Signature]</i> 07.10.18	
Comment : Est Rev: A New Issue 06-02-03 JLM	

*OK REC MARKING
on SHEET 2084*

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34813	Angle bracket
-----	--------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3481-3	Bracket	<i>B34407</i>

CP 07/11/05 (5)

2.0	QC200566 <i>Q5200525</i>	<i>07.10.18</i> CLAMP
-----	-------------------------------------	-----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	QC200566 <i>Q5200525</i>	Clamp	<i>M1056 03</i>

Q5200525

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3481

2-Spot Weld as per Dwg D3481

CP 07/11/05 (5)

4.0	QC11	VISUAL INSPECTION OF SPOT WELDING
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Comment: VISUAL INSPECTION OF SPOT WELDING

803 07/11/05

(5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 21/10/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 7:59:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET & CLAMP ASSEMBLY

Job Number: 35192

Part Number: D3481043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8B 07/11/5

(5)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

8B 07/11/5

(5)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/11/06

(5)

Job Completion



CL07/11/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3481	REV. A SHEET 1 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 2:3
A	06.01.23	NEW ISSUE	

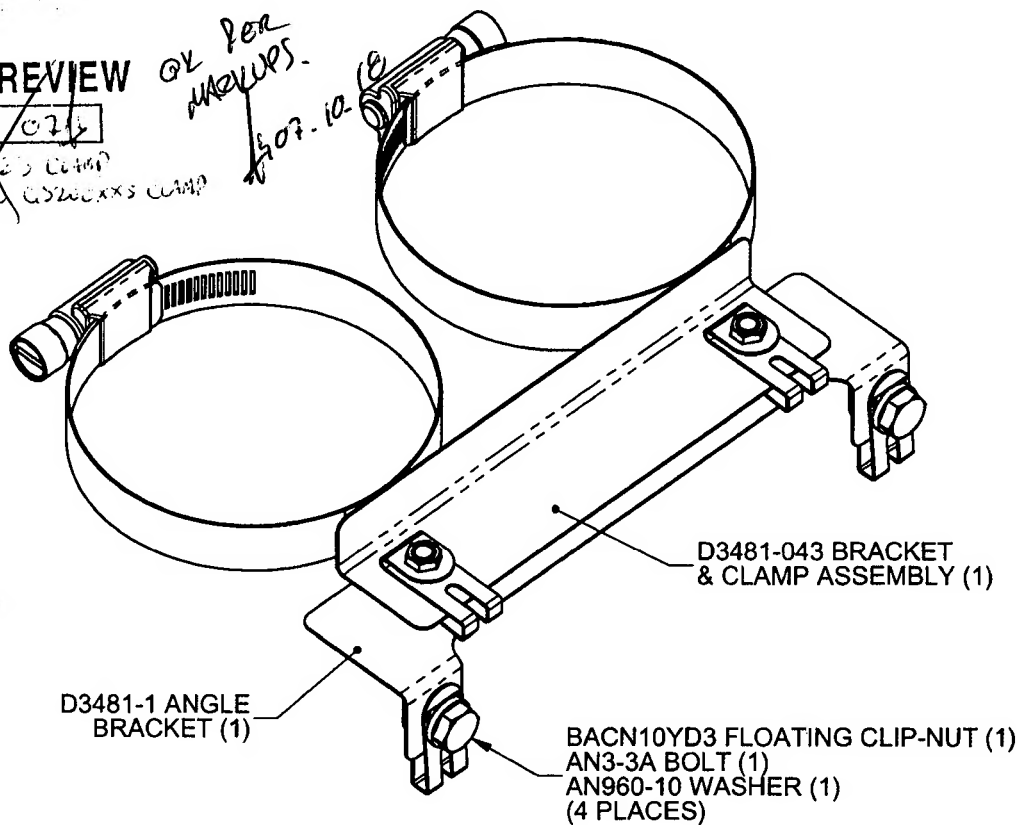
06.04.03
UNDER REVIEW

07.04.02

*Q520000'S CLAMP
CHANGED TO Q520000'S CLAMP*

*OK Per
MELUOS.*

07.10.12



D3481-041 SHUT-OFF VALVE BRACKET

- 1) IDENTIFY WITH DART P/N D3481-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3481-041	SHUT-OFF VALVE BRACKET
1	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-1	ANGLE BRACKET
4	AN3-3A	BOLT
4	AN960-10	WASHER
4	BACN10YD3	FLOATING CLIP-NUT

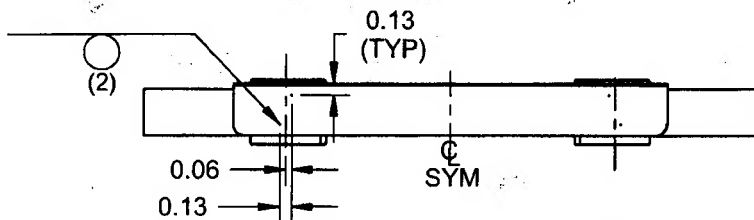
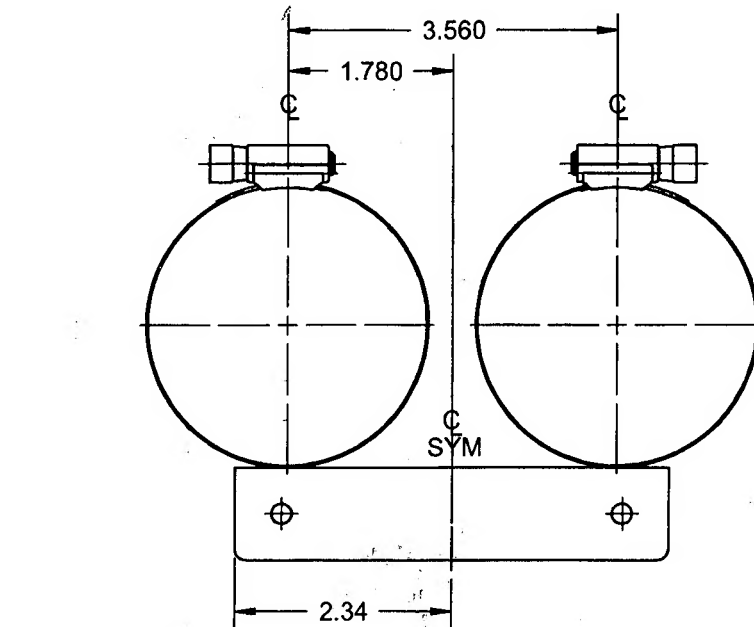
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WORK ORDER
NO. *35192*

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DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. A SHEET 2 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



Q5200525
Q5200563
AERO-SEAL CLAMP
(2 PLACES)

[Signature] 06.04.03

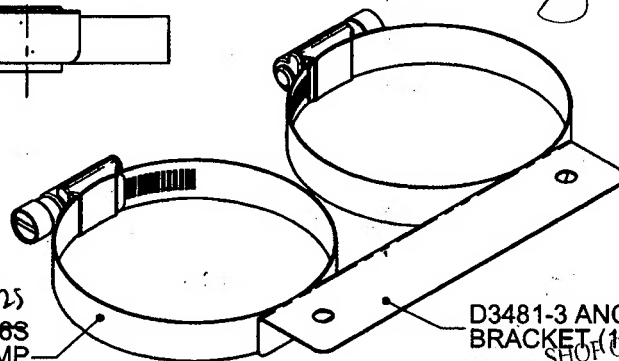


02 per max 485
02.10.16

UNDER REVIEW

07.07.07

Q5200563 CLAMP
CHANGED TO Q5200563 CLAMP



D3481-3 ANGLE
BRACKET (1)
SHORT COPY

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D3481-043 BRACKET & CLAMP ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

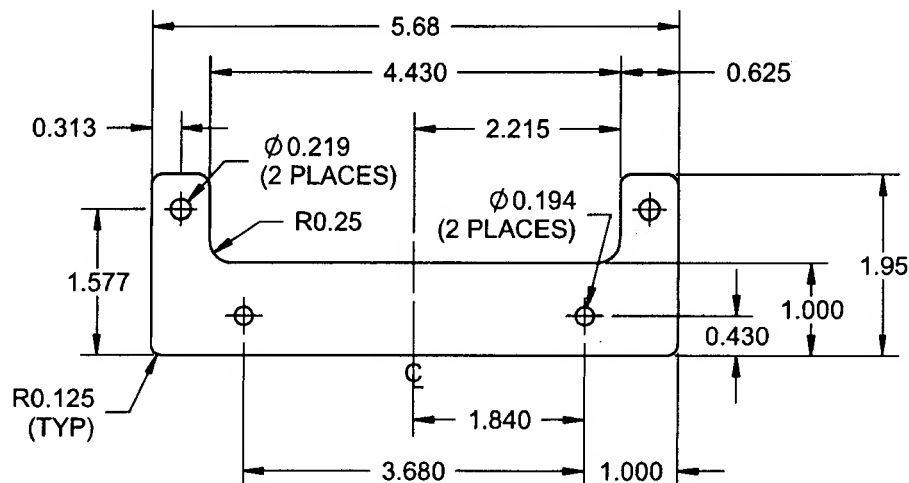
QTY -041	P/N	DESCRIPTION
X	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-3	ANGLE BRACKET
2	Q5200525	
	Q5200563	AERO-SEAL CLAMP

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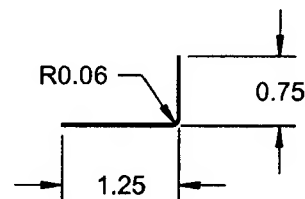
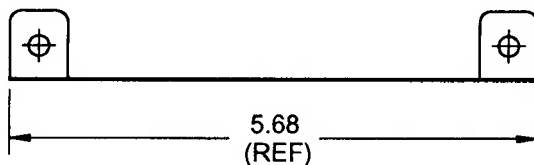
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. A SHEET 3 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



D3481-1F FLAT PATTERN

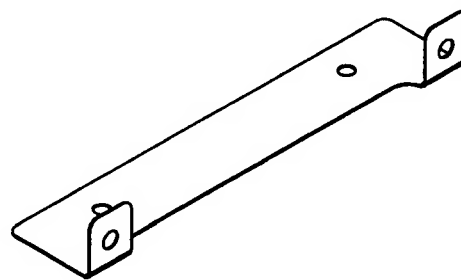


D3481-1 ANGLE BRACKET

[Handwritten signature] 06.04.03

UNDER REVIEW

07.09.07
Q5200705 CAMP
CHANGED TO Q5200XXS CAMP



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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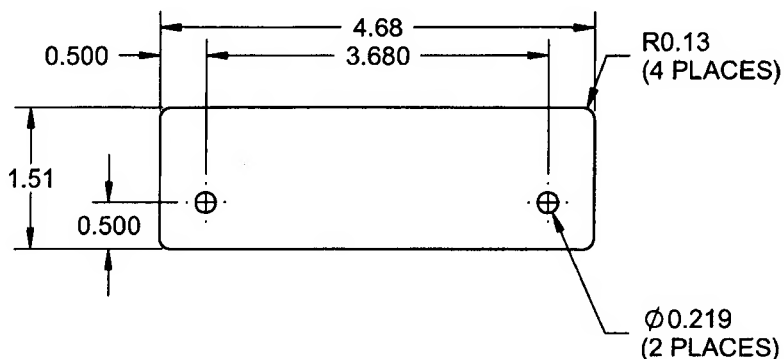
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. A SHEET 4 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

UNDER REVIEW

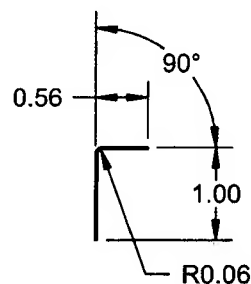
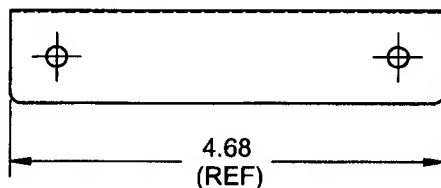
07.09.02

Q5200705 COMP
CHANGED TO Q5200705 COMP

06.04.03



D3481-3F FLAT PATTERN



D3481-3 ANGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 39

EMPLOYEE: Emile Boucker

PART NUMBER: D 3481-043

JOB NUMBER: 35792

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 0.018

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☒

Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<u>/</u>]	[]
PENETRATION:	[<u>/</u>]	[]
PULL STRENGTH:	[<u>/</u>]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/11/05
QUALIFIER: SB